

Date: Tuesday, 12/5/2006 8:16:24 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 29789		
Estimate Number	: 10764		
P.O. Number	: N/A	Part Number	: D2876
This Issue	: 12/5/2006	Drawing Number	: D2876 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 28016	Material	: NOTE:1 BLANK MAKES 4 PARTS
Written By	: <u>DK</u> Ob 12 05	Due Date	: 1/15/2007 Qty: 120 Um: Each
Checked & Approved By			
Comment	: Esr Rev:B 00.05.19 Added inspect level 8 EC Est Rev:C Now M6061-T6 06-06-23 JLM		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S100	6061-T6 .100 Sheet	
Comment:	Qty.: 0.0542 sf(s)/Unit Total : 6.5016 sf(s)		
Material:	6061-T6 (QQ-A-250/8) 0.100" Thick		
Batch:	<u>M102201</u> ml ob 12 11	(120)	
2.0	WATER JET	Prog Rev: <u>B</u> FLOW WATER JET	
		Dwg Rev: <u>B</u> ml ob 12 12	(120)
Comment:	FLOW WATER JET		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		ml ob 12 12	(120)
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK	
		Job-12-12 (120) control no	
Comment:	SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		22 Dec 06 (Finish) (120)	
Comment:	SMALL & MEDIUM FAB RESOURCE 1		
	Remove tabs and Tumble		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		m JL/LL 06/12/28 (120)	
Comment:	HAND FINISHING RESOURCE #1		
	Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE SPACER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



11/08/28



(20) ~~11/08/28~~

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



~~11/08/28~~



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST393

CB 06/12/29 (20) 12/01/02

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/02

Job Completion



CB 07/01/02

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29789
Description: Saddle Spacer	Part Number:	D2876
Inspection Dwg: D2876 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

12/11

12

Measured by:	<u>Mark. W.W.</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	08/12/12	Date:	08/12/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	
B	04.06.15	Removed 0.250 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

DART

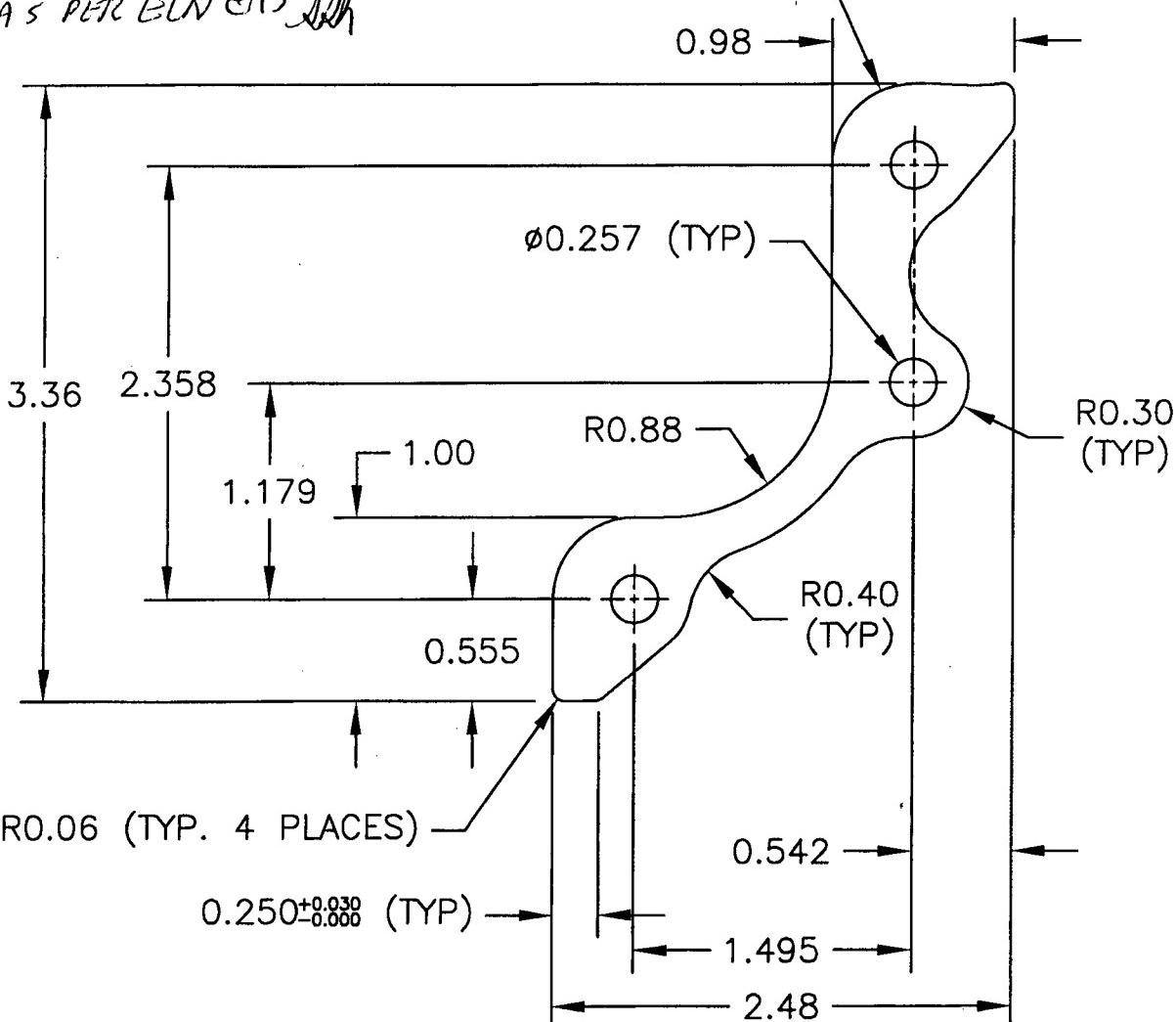
DESIGN	4P	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	H	DRAWING NO. D2876 REV. B SHEET 1 OF 1
DATE	06.06.02			TITLE SADDLE SPACER SCALE 1:1
A	99.02.23			
B	06.06.02			MATERIAL CHANGE

RELEASED

06.06.22

AS PER BCN & 13

R0.44 (TYP 2 PLACES)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29789

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